

RE-Print

Push

Work Order ID 111880

February-05-14 2:54:26 PM

D3566-1

111880

Page 1

Item ID: D3566-1

B111880

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket Fwd & Aft

Stop

NS2

Start Date: 24/01/2014 Start Qty: 16.00

16

Cust Item ID:

Required Date: 07/02/2014 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: 

Date: 14-02-05

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3566

Rev C

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3566 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

neo .063"

14 0 Ae
14-02-05

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

14 0 Ae
14-02-05

DAS
27
9-89

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

14/2/16

14

Work Order ID 111880

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111880

Page 2

Item ID: D3566-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket Fwd & Aft

Start Date: 24/01/2014 Start Qty: 16.00

16

Cust Item ID:

Required Date: 07/02/2014 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: FP-001

0.00

130

Packaging

Memo

0.00

Packaging

x14 d 40 1402106

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 140206
MLJ 1402-06

Picklist Print

February-05-14 2:54:32 PM

Page 1

Work Order ID: 111880

111880

Parent Item: D3566-1

D3566-1

Parent Item Name: Gasket Fwd & Aft

Start Date: 24/01/2014

Required Date: 07/02/2014

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased		No		100	sf	44.1000	0.911	17			

MNEO60S 063
NEOPRENE SHEET 0.063

**

Ac 14-02-05

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT052	44.1	
<u>M126546</u>	44.1	

126546 → 17

DART AEROSPACE LTD		Work Order:	111380
Description: Gasket		Part Number:	D3566-1
Inspection Dwg: D3566 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

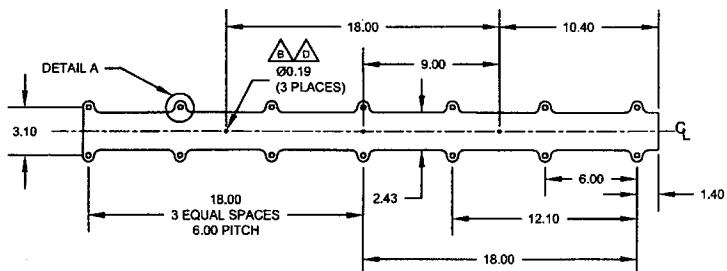
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3.10	-		✓	JKm-05
18.00	+/-0.030	18.00	-		T	JKm-06
12.10	+/-0.030	12.10	-		T	
2.43	+/-0.030	2.43	-		✓	
6.00	+/-0.030	6.00	-		T	
1.40	+/-0.030	1.40	-		✓	
0.30	+/-0.030	.30	-		✓	
0.30	+/-0.030	.30	-		✓	
0.063	+/-0.010	.063	-		✓	
Ø0.188	+0.005/-0.001	.188	-		✓	

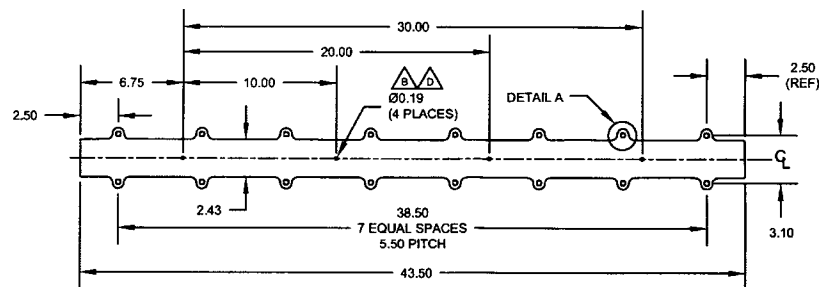
Measured by: Ae	Audited by: DAS 27 9-89	Prototype Approval:	N/A
Date: 14.02.05	Date: 14/2/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC/DD	EE

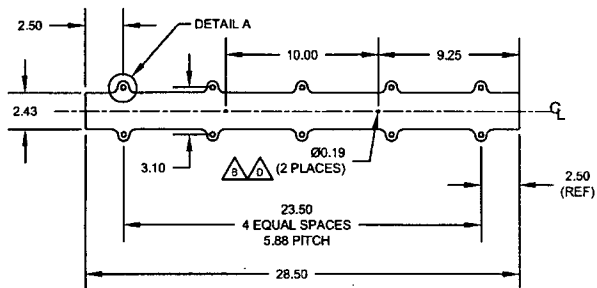
8 7 6 5 4 3 2 1



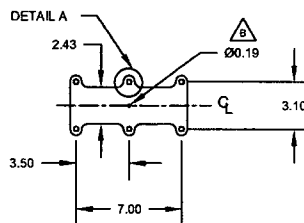
D3566-1 GASKET



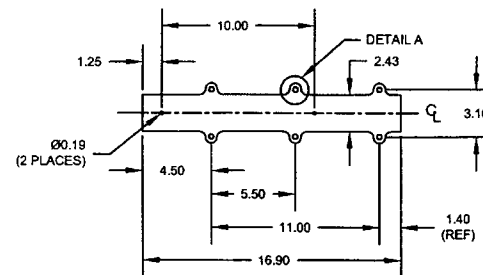
D3566-5 GASKET



D3566-7 GASKET



D3566-13 GASKET

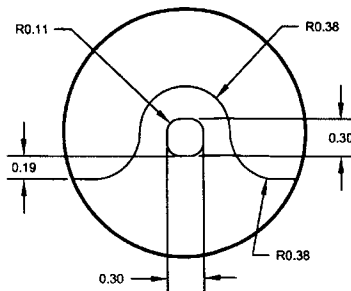


D3566-15 GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 111880
14-02-05

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT C



DETAIL A
SCALE 1:1

WEIGHTS:

D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

RELEASED

07.08.04

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3566 TITLE GASKET SCALE 1:8 REV. C SHEET 1 OF 1 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			